

41 _____ Dr
14/01/05

Work Order ID 110099

December-17-13 9:14:58 AM

110099

Page 2

Item ID: D3898-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Floor Protector (206L)

Start Date: 12/12/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110						<u>X</u>			<u>Wh</u>
Thermoform	Memo	0.00							<u>14/01/25</u>
Thermoforming Machine	1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9501 Dwg Rev: <u>A</u> Folio Rev: <u>B</u> Visually inspect for proper formation and texture								
140		0.00							
140						<u>X</u>			<u>B 14/01/27</u>
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
150						<u>X</u>			<u>B 14/01/27</u>
QC	Memo	0.00							
Quality Control	Complete FAI document								

Work Order ID 110099

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Item ID: D3898-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Floor Protector (206L)
Start Date: 12/12/13 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 12/17/13 Req'd Qty: 1.00 ***1*** Customer:
Reference:


Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00				1			
160									
QC	Memo	0.00							
Quality Control									

170	Identify as per dwg & Stock Location: _____	0.00							DAS 32 9-89
170									
Packaging	Memo	0.00							
Packaging									

180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

ML5 1401-29
 14-01-28

Picklist Print

December-17-13 9:14:57 AM

Page 1

Work Order ID: 110099

Parent Item: D3898-1

Parent Item Name: Floor Protector (206L)

Start Date: 12/12/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev.A New Issue 09/02/06 DL
10/04/21 DL

IPP RevB Add Step 105 Dry Material

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 Lexan Sheet		Purchased	No			100	sf	3,378.1600	10.6	12			

Location

Loc Qty

Loc Code

therm

3378.16

113127

2.16

m126994

3376

1259 Rt

OK
14/01/25

DART AEROSPACE LTD		Work Order:	110099
Description: Floor Protector		Part Number:	D3898-1
Inspection Dwg: D3898 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JB Date: 14/01/27

TRIMMING SECTION

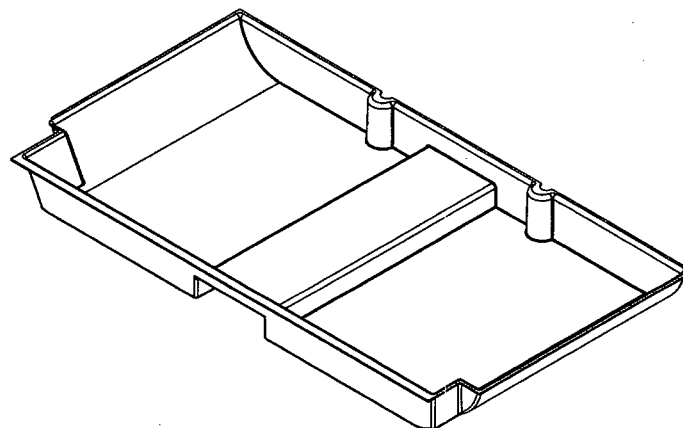
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.50	Min	5.636	✓		TH - 01	
1.00	Min	1.017	✓		TH - 01	
5.6	+0.2/-0.0	5.631	✓		TH - 01	
0.080	Min	.086	✓		TH - 01	
0.050	Min	.112	✓		TH - 01	

Measured by: JB Date: 14/01/27

Audited by: 21 Date: 14/1/28

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>JB</u>



110099 MLS
13-12-19

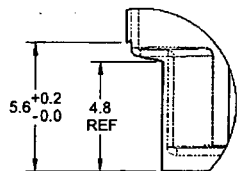
D3898-1 FLOOR PROTECTOR (206L)

RELEASED
29/06/08 MLD

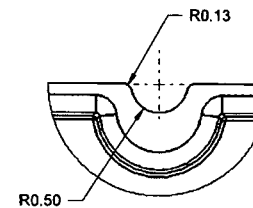
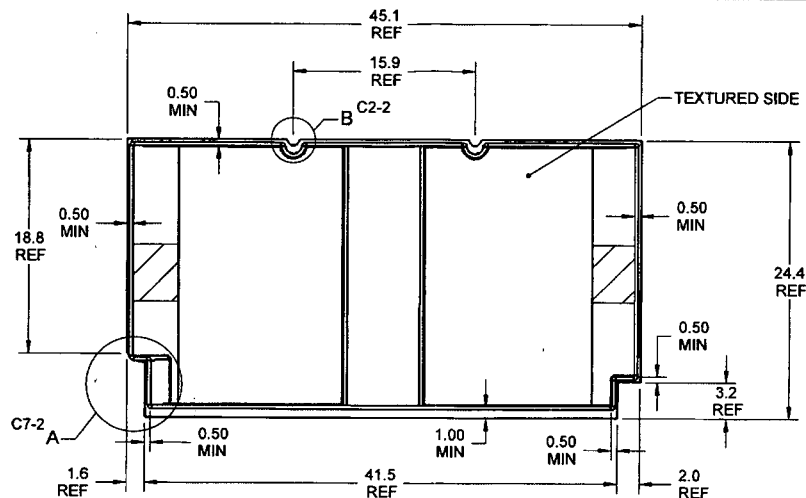
NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS
- 7) WEIGHT: 5.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

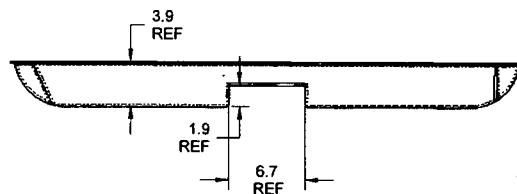
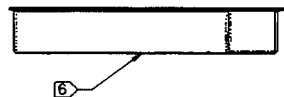
A	NEW ISSUE	PH	09.02.27
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3898	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR (206L)	NTS
DATE	09.02.27	<small> COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	



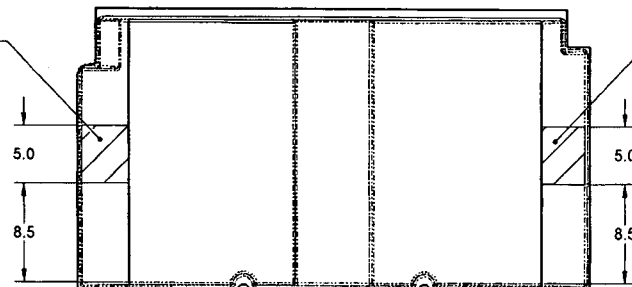
DETAIL A
SCALE 2X



DETAIL B
SCALE 5X
2 PL



MIN THICKNESS
0.080
(SHADED REGION)



MIN THICKNESS
0.080
(SHADED REGION)

D3898-1 FLOOR PROTECTOR (206L)

RELEASED
09/06/08

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3898	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR (206L)	NTS
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